

634-011

Dart Aerospace Ltd.

Date: Tuesday, 10/03/2009 10:48:11 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SKID TUBE ASSEMBLY
Job Number :	46376A		
Estimate Number :	10023		
P.O. Number :		Part Number :	D205634041
This Issue :	10/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2580 REV D
First Issue :	1/1	Project Number :	N/A
Previous Run :	46374A	Drawing Revision :	D
		Material :	
Written By :		Due Date :	23/03/2009
Checked & Approved By :	JUL 09.03.10	Qty:	1 Um: Each
Comment :	Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ Est Rev: O 06.02.28 Added paperwork EC Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A 12

2.0

D2500-1-190

Ext'n -1" Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B-40150

AWM 9-3-11

3.0

D2596

Web, 205 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2596

205 Web

B46408

AWM 09-03-12

4.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Debur ends

3-Acid etch and Alodine tube per QSI 005 4.1

AWM 9-3-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 46376A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

① 119-3-11

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580without cutting fluid

3-Countersink holes as per Dwg D2580without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	m109883	
Sikaflex expire date: 09-07-11			
Start Time: 1:45 PM		Date: 09-03-12	
Fin Time: 7:15		Date: 09-03-13	

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

MB

09-03-13

①

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

MB 09-03-16 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 46376A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 09/03/16

10.0

D25763

Step (maching detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	843504

BE 09/03/16

6

11.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	B43988

Pr 09-03-16

20

12.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

m110676 BE 09/03/16

3-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

m110676 BE 09/03/16

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

AWM 9-3-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 46376A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 02/03/17 (X)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/03/17 (X)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

Q.M 09.03.31 (X)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:45

OVEN TEMPERATURE:

320°

FINISH TIME:

12:15

CMR BR

09/03/31 (X)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-01 (X)

18.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: B412343

MS

19.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M100188

MS

09-04-01

(X)

Dart Aerospace Ltd

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Job Number: 46376A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M1109632

ul

21.0

ALS71032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch: (30x) M110985 / (20x) M111279

M1108606

ul

22.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch: (30x) M110985 / (20x) M111279

ul

23.0

AN960C10L

washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

washer

Batch: M111193

ul

24.0

D356613

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B46493

ul

25.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B46186

ul

26.0

D35661

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B46349

ul

09-04 x 01

(21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 46376A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B45409 ✓

✓

28.0

D356411

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B45823

✓

29.0

D35649

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B45825

✓

30.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B46184

✓

31.0

D25943

O-Ring, 205 Skidtube



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch: B29908

✓

32.0

D25941

Plug, 205 Skidtube



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch: B46435

✓

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

M1109885

✓

09-04-01

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 46376A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ Sikaflex expire date: 09/11

✓ 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

✓ 3-Inspect for foreign object per QSI 024

✓ 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

— A/R Sikaflex-291 11109883
Sikaflex expire date: 09/11

9309-04-01 (X)

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 1109883

— Fd 09/04/01 (X)

34.0

QC5

INSPECT WORK TO CURRENT STEP



Scrub (X)



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



(X)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

PPD 46376

9/4/6

50

36.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/08 (X)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



WF 09-04-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. H0376A

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RELEASED
07-06-28-11

Diagram illustrating the grinding locations for the propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{16}$

40.208
 DRILL PRIOR TO 02855 CAP
 INSTALLATION (2 PLACES)
 AN3-5A BOLT (1)
 AN960J10L WASHER (1)
 (2 PLACES)
 02855 CAP
 SEAL WITH
 SIKAFLEX-241/-291
 0.40

Diagram illustrating the wheel assembly components and steps:

- 02579 SPACER
- WEB (REF)
- WEB (REF)
- AFTER PERFORM
 1. CHA
 2. INS
 3. WE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO $\phi 0.437$ X 1.00 DEEP

i) **FINISH:** ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

[illegible]

0.5

1.5

1.5

D

P P P P P P P

8

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

REFER TO DETAIL C

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)

DESIGN JJ DRAWN BY

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DESIGN	<i>[Signature]</i>	DRAWN BY	<i>PH</i>
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>
DATE			
07.02.27			

DART		DART AEROSPACE LTD. WAINESBURY, ONTARIO, CANADA	
DRAWING NO. D2580		REV. D SHEET 2 OF 3	
TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24	

RELEASED
07 Dec 78

Diagram illustrating the grinding locations on a propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a circular component, likely a cap or cover, showing various fasteners and dimensions. The drawing includes the following labels and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to two locations on the circular component.
- SEAL WITH SIKAFLEX-241/-291**: Points to the seal area.
- AN3-5A BOLT (1)**: Points to a bolt on the component.
- AN960JD10L WASHER (1)**: Points to a washer on the component.
- (2 PLACES)**: Points to two locations on the component.
- D2855 CAP**: Points to the cap itself.
- SEE NOTE ii)**: Points to a specific location on the component.
- 0.40**: Dimension indicating a distance or thickness.

The drawing also includes the text **UNCC** and **SUBJ** at the bottom left.

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

[illegible]

(MAKE FROM D2580-1 DRILLING DETAIL)

Technical drawing of a horizontal curve showing dimensions and callouts. The drawing includes the following dimensions and features:

- Overall length: 51.340
- Distance from start to first tangent point: 5.338 (REF)
- Distance between tangent points: 39.580
- Distance from second tangent point to end: 5.915
- Radius: $\phi 0.508$ (8 PLACES)
- Offset dimension: 5.985
- Offset dimension: 1.4
- Offset dimension: 20.0
- Offset dimension: 11
- Offset dimension: 0.640
- Callout 4 (triangle symbol) pointing to the start of the curve.
- Callout 4 (triangle symbol) pointing to the end of the curve.
- Dimension 1.0: DISTANCE BETWEEN HOLE AND TANGENT POINT (two locations).
- Dimension 13.4: DISTANCE BETWEEN HOLE AND TANGENT POINT.
- Dimension 32.0 ± 1.0 : DISTANCE BETWEEN HOLE AND TANGENT POINT.

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

NO C'BORE NO PLUG

NO C'BORE NO PLUG

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)

DESIGN	DRAWN BY
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DESIGN

PH

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DATE	07.02.27
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DRAWN BY

R6

APPROVED

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DART

DRAWING NO.
00500

U2580
TITLE
205 SKIPTUE

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

RE

ASSEMBLY

NO. 187

**AWS D17.1.2001
QUALIFICATION TEST RECORD**

Name: Barclay Elliot
Job number: 844417
Part number: A205-634-041
Description: 20S Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier: David Hand Date of Test Coupon 09/01/13
Welder: Barclay Elliot Date of Test Coupon 09/01/13

The above named individual is qualified in accordance with AWS D17.1.2001 to weld